

ork Order ID 84682

lay-17-12 3:02:05 PM

-2
SPLIT-2

84682

Page 1

Item ID: D3282-041

Revision ID:

Item Name: Float Web (206L/407)

Start Date: 17/05/2012 Start Qty: 10.00

Required Date: 15/06/2012 Req'd Qty: 10.00

Reference:

Accept

N9000040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approval:

Process Plan: *MLJ*

Date: *12/05/22* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3282	D

100

100

Skidtubes

Skidtubes

Skidtubes

Memo

1-Cut to length as per Dwg D3282.
2- inspect for surface damage as per QSI0018
3- Deburr

0.00

0.00

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per Folio FA579 & Dwg D3282
2-Deburr

0.00

0.00

120

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

10 *12-05-23*

PTC

ork 12/08/06

10 *0*

ork 12/08/06

10 *0*

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Page 2

Item ID: D3282-041

Revision ID:

Item Name: Float Web (206L/407)

Start Date: 17/05/2012 Start Qty: 10.00

Required Date: 15/06/2012 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

12/08/07

10

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

10

767

12-89

Hand Finishing

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

12/08/10

Quality Control

Work Order ID 84682

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84682

Page 3

Item ID: D3282-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Float Web (2061/407)

Start Date: 17/05/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tcol ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Install doublers as per Dwg D3282.								
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>LC</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									

CF

12-8-10

(#7)

16

DAS 16

12/05/14

3/2/08/14

Work Order ID 84682

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Page 4

Item ID: D3282-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Float Web (206L/407)

Stop *NS2*

Start Date: 17/05/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

17/05/2012

17/06/2012

Picklist Print

May-17-12 3:02:09 PM

Page 1

Work Order ID: 84682

Parent Item: D3282-041

Parent Item Name: Float Web (206L/407)

84682

D3282-041

Start Date: 17/05/2012

Required Date: 15/06/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:B05.09.23Procedure changeKJ/JLM
remove LPS as per dwg revD DD verf:JLM

IPP REV:C 11.09.20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2792-130		Manufactured	No			100	Each	21.0000	1	10			
D2792-130													
EXTRUSION													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT006		21							
				72839		21							

D3283-1		Manufactured	No			160	Each	24.0000	2	20			
D3283-1													
Doubler													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST176		24							
				82125		24							

MS20470AD4-7		Purchased	No			160	Each	1,503.000	57	570			
MS20470AD4-7													
Rivet, Universal Head													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST139		1186							
				121415		1186							
				ST319		52							
				120769		52							
				ST320		265							
				116081		117							
				118614		148							

570

11-05-23

CF 12-8-9

CF 12-8-9

DART AEROSPACE LTD		Work Order: 84682
Description: Float Web		Part Number: D3282-041
Inspection Dwg: D3282	Rev: D	Page 1 of 1

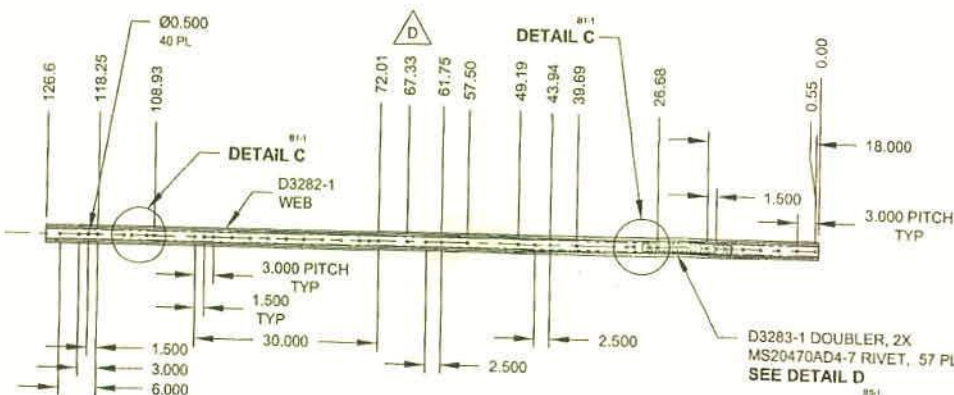
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.620	✓		Plan M-type 17L-04	
1.500	+/-0.010	1.500	✓		Vern 17L-04	
3.000	+/-0.010	3.000	✓		"	
6.000	+/-0.010	6.000	✓		"	
1.250	+/-0.010	1.250	✓		"	
30.000	+/-0.010	30.000	✓		M-type 17L-04	
1.500	+/-0.010	1.500	✓		"	
72.01	+/-0.030	72.010	✓		"	
61.75	+/-0.030	61.750	✓		"	
57.50	+/-0.030	57.500	✓		"	
49.19	+/-0.030	49.190	✓		"	
43.94	+/-0.030	43.940	✓		"	
39.69	+/-0.030	39.690	✓		"	
26.68	+/-0.030	26.680	✓		"	
0.55	+/-0.030	0.555	✓		Vern 17L-04	
1.970	+/-0.010	1.970	✓		"	
2.38	+/-0.030	2.380	✓		"	
0.05	+/-0.030	0.055	✓		"	

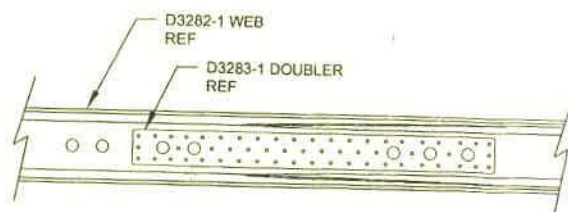
Measured by: gmf	Audited by: B.A.	Preliminary Approval:
Date: 12/08/06	Date: 12/08/07	Date:

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	12.02.01	Dwg Rev updated	KJ	

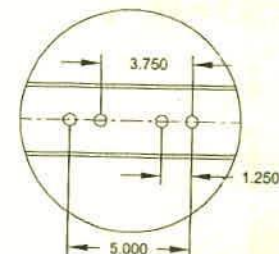
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 24682 MLJ
12/05/22



D3282-041 WEB



DETAIL D



DETAIL C

NOTE: RIVET HOLES/DOUBLER
NOT SHOWN FOR CLARITY

RELEASED
2011-09-12
NT

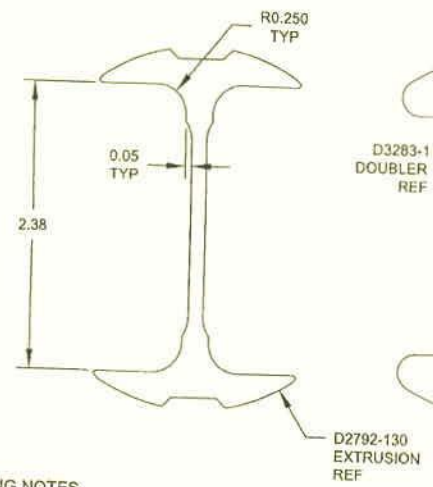
NOTES:

- 1) MAKE D3282-1 WEB FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3282-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 20.0 lbs
- 8) SEE PAGE 2 FOR MACHINING DETAILS

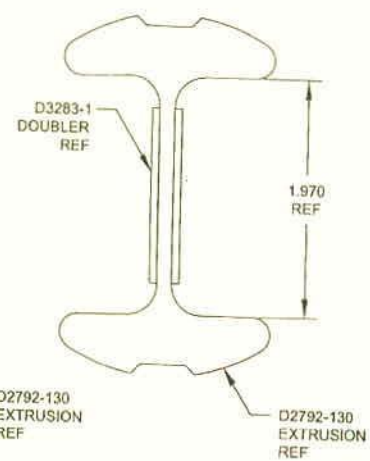
D	ADD ADDITIONAL HOLE (ZN D6-1), REMOVE LPS-3 (ZN C3-1)	SC	11.05.05
C	REMOVE D3390-1, NOW MACHINED	CP	05.08.09
B	MOVE HOLES, ADD D3390-1 DOUBLERS	CP	05.03.16
A	NEW ISSUE	CP	04.05.05
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	g	DRAWING NO.	REV. D
MFG. APPR.	BE	D3282	SHEET 1 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	TH	WEB	NTS
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84682

SECTION A-A

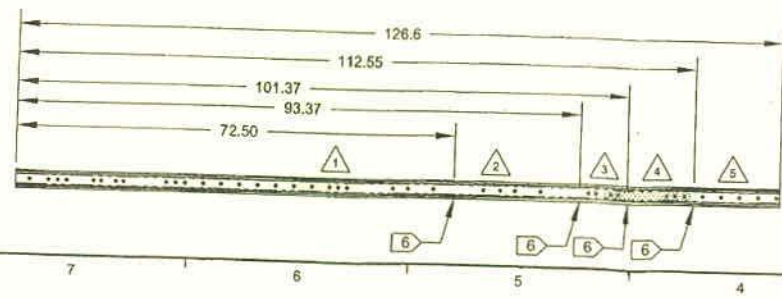


SECTION B-B



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 4 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	GP	DRAWING NO.	REV. D
MFG. APPR.	GP	D3282	SHEET 2 OF 2
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	WEB	NTS
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